

Work Order ID 85852

June-15-12 2:22:37 PM

ASAP

85852

Page 1

Item ID: D4148-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Crosstube Lug Plate, Fwd

Start Date: 15/06/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 22/06/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/15

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4148	D

(20)

100		0.00
-----	--	------

100

Waterjet

Memo

0.00

B12-6-16

FLOW CNC Waterjet

Cut as per dwg D4148

304 .125"

Prog Rev: B
Dwg Rev: D

Deburr as required

110	QC2- Inspect parts off machine FAI/FAIB	0.00
-----	---	------

110

QC

Memo

0.00

B12-6-16

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 85852

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Page 2

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N900040100

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Cust Item ID:

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

5/12/20/20

Quality Control

cate
(120)

150

Identify as per dwg & Stock Location: 101

0.00

150

Packaging

Memo

0.00

Packaging

20

12/16/20 JB

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

12/16/20 JB

12-06-20

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Picklist Print

June-15-12 2:22:41 PM

Page 1

Work Order ID: 85852

85852

Parent Item: D4148-1

D4148-1

Parent Item Name: Crosstube Lug Plate, Fwd

Start Date: 15/06/2012

Required Date: 22/06/2012

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP Rev:A 10.06.24 new issue DD verf:EC

IPP Rev:B 10.10.29 as per revC DD verf:EC

11.03.02 AS PER DWG REV.D DD VERF:EC

IPP REV:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No			100	sf	96.0760	0.3607	7.593684			

M304S11GA

**

812-6-16

304/316 0.125 Sheet

Location

Loc Qty

Loc Code

MAT020

96.076

121380

24.9

121780

71.176

121780

620

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order:	05852
Description: Fwd Crosstube Lug Plate		Part Number:	D4148-1
Inspection Dwg: D4148	Rev: D	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	.130	2		V	1302
Ø0.191	+0.005/-0.001	.191	2		V	
Ø0.38	+0.006/-0.001	.379	2		V	
Ø0.257	+0.006/-0.001	.258	2		V	
Ø0.50	+0.008/-0.001	.494	2		V	
0.94	+/-0.030	.94	2		V	
4.47	+/-0.030	4.478	2		V	
0.750	+/-0.010	.760	2		V	
8.47	+/-0.030	8.467	2		V	PROWSD2
8.096	+/-0.010	8.096	2		V	
5.43	+/-0.030	5.436	2		V	
5.197	+/-0.010	5.196	2		V	
4.733	+/-0.010	4.736	2		V	
0.310	+/-0.010	.310	2		V	
0.750	+/-0.010	.751	2		V	
0.375	+/-0.010	.386	2		V	
1.84	+/-0.030	1.839	2		V	
0.92	+/-0.030	.918	2		V	
3.000	+/-0.010	2.997	2		V	
0.750	+/-0.010	.756	2		V	
0.625	+/-0.010	.625	2		V	
1.982	+/-0.010	1.980	2		V	
0.991	+/-0.010	.990	2		V	
0.77	+/-0.030	.771	2		V	
1.54	+/-0.030	1.539	2		V	
2.47	+/-0.030	2.468	2		V	
0.82	+/-0.030	.82	2		V	
3.57	+/-0.030	3.573	2		V	
1.23	+/-0.030	1.236	2		V	
0.73	+/-0.030	.73	2		V	
0.125	+/-0.010	.120	2		V	
Ø0.252	+0.003/-0.000	.253	2		V	

Measured by: B	Audited by: S	Preliminary Approval:
Date: 12-6-16	Date: 12/6/20	Date:

Rev	Date	Change	Revised by	Approved
A	10.08.04	New Issue	KJ	
B	10.10.08	Dwg Rev updated	KJ	
C	10.11.05	Dimensions updated per Dwg Rev C	KJ	
D	11.03.08	Dwg Rev updated	KJ	
E	12.02.01	Dimensions updated per Dwg Rev D	KJ	

Dart Aerospace Ltd

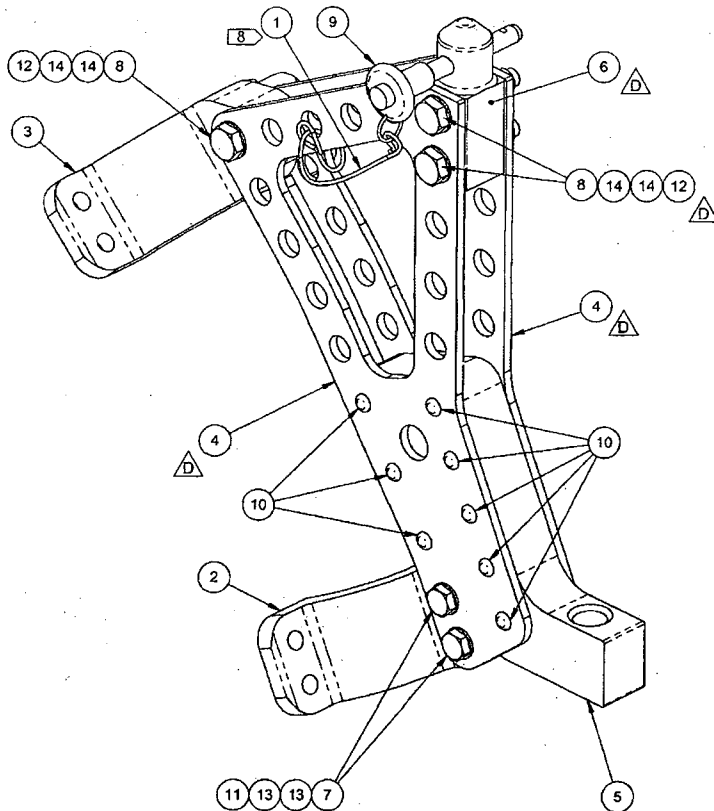
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NOTE: Date & initial all entries



D4148-041 FWD X-TUBE LUG ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4148-041" PER DART QSI 044 6.1
- 7) WEIGHT: 3.67 lbs
- 8) ATTACH D2690-6 TO D4148-1 BY LOOPING AROUND A LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4148-041	FWD X-TUBE LUG ASSY
1	1	D2690-6	LANYARD
2	1	D3910-1	X-TUBE LUG
3	1	D4091-1	MOUNTING LUG
4	2	D4148-1	FWD X-TUBE LUG PLATE
5	1	D4148-3	STUD RECEIVER LOWER
6	1	D4148-5	EYEBOLT STUD
7	2	AN3C12A	BOLT
8	3	AN4C13A	BOLT
9	1	MS17984-C413	PIP PIN
10	8	MS20615-4M18	RIVET
11	2	MS21043C3	NUT
12	3	MS21043C4	NUT
13	4	NAS1149C0332R	WASHER
14	6	NAS1149C0432R	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

NO. 05852 MLJ
12/06/15

RELEASED
R 2011-02-24

D	HOLE DIA CHANGED TO 0.252" (D8-3); HOLE DIA CHANGED TO 0.250" (C8-5); REPLACED QTY(2) AN3C12A, MS21043C3 AND QTY(4) NAS1149C0332R WITH QTY(2) AN4C13A, MS21043C4 AND QTY(4) NAS1149C0432R (D3-1,C4-2)	SC	11.02.22
C	REDESIGNED D4148-1/3 TO ADDRESS COMPATIBILITY ISSUES WITH D350-591 SHORT STEPS	MB	10.10.12
B	REPLACED QTY(3) MS20615-4M18 WITH QTY(2) EACH AN3C12A, MS21043C3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1, B7-2 & B4-2); MS20615-4M18 WAS MS20615-4M20 (ZN D3-1 & B7-2); Ø0.191 2 PL REPLACES Ø0.129 3 PL (ZN D6-3); Ø0.129 7 PL WAS 10 PL (ZN A7-3); Ø0.191 WAS 0.129 (ZN C8-3); REASON: SEE TR-D350-607-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.06.18
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4148	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		FWD X-TUBE LUG ASSY	NTS
DATE	11.02.22	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

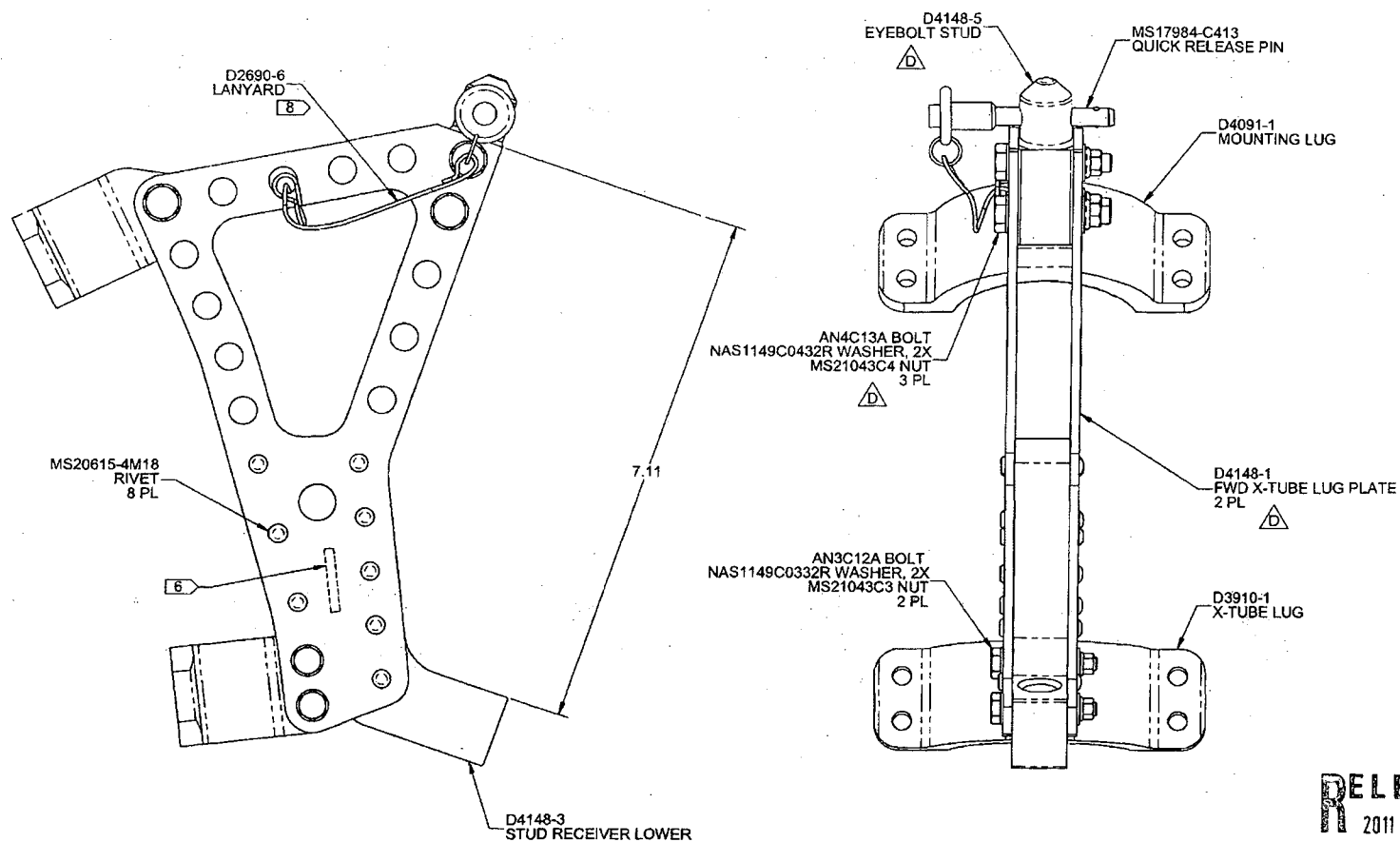
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____



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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4148-041 FWD X-TUBE LUG ASSY

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DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4148	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		FWD X-TUBE LUG ASSY	NTS
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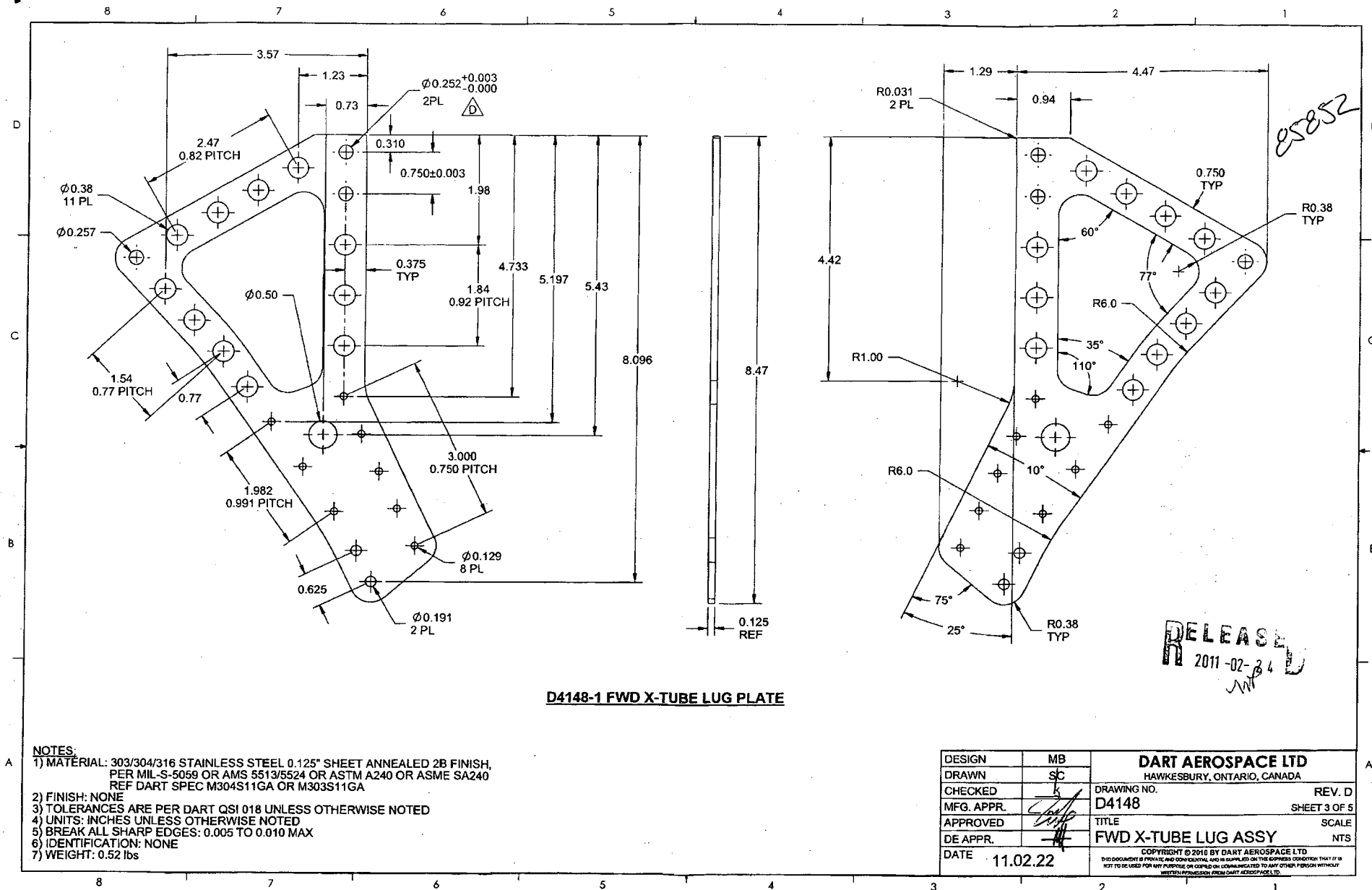
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NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.52 lbs

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO. D4148	REV. D
MFG. APPR.			SHEET 3 OF 5
APPROVED		TITLE FWD X-TUBE LUG ASSY	SCALE NTS
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DATE	11.02.22		

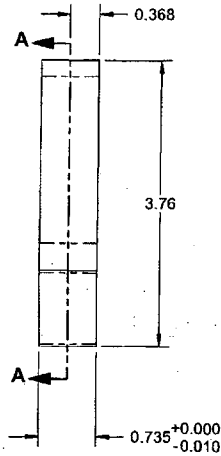
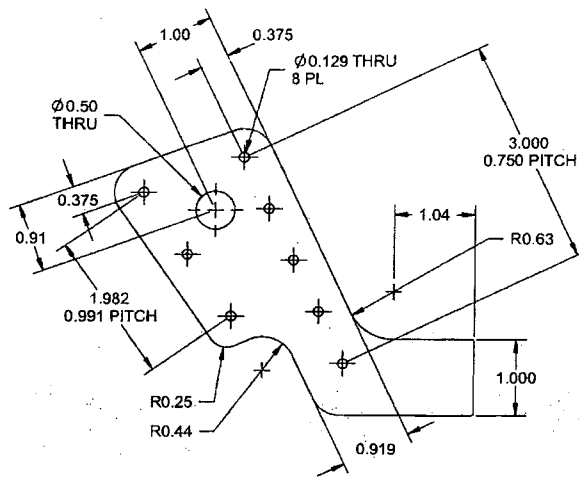
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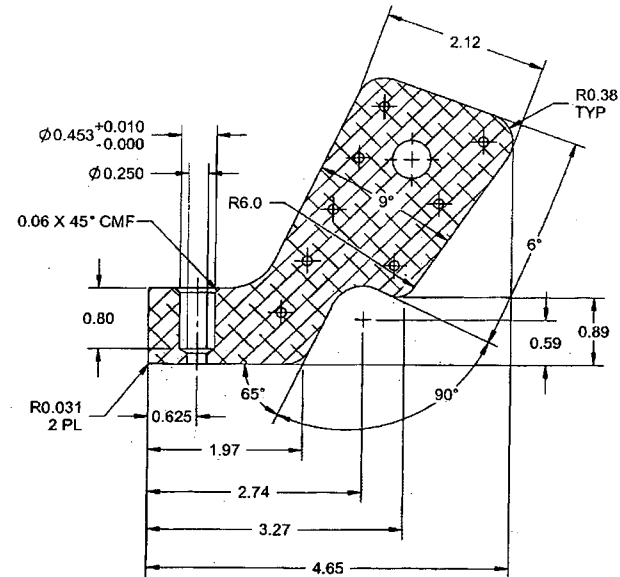
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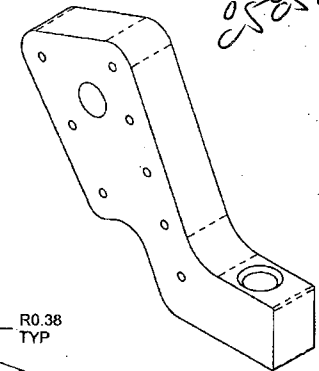
NOTE: Date & initial all entries



D4148-3 STUD RECEIVER LOWER



SECTION A-A



NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276
REF DART SPEC M304B OR M303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.52 lbs

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D4148	SHEET 4 OF 5
APPROVED		TITLE	SCALE
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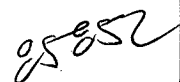
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NOTE: Date & initial all entries



D4148-5 EYEBOLT STUD

2-240

1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276
REF DART SPEC M304B OR M303B

- 7) WEIGHT: 0.27 lbs

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